

Add Process Sheet

Client Name *

Select Client Name

Item Group *

Select Item Group

Branch Name

Select an Option

Product Name *

Select an Option

Mold Code *

Select Mold Code

Machine *

Select Machine

Number Of Cavities *

Enter Number Of Cavities

Net Weight Piece (kg) *

Enter Net Weight Piece (kg)

Runner Shots *

Enter Runner Shots

Net Weight *

Net Runner Weight *

Loss *

Enter Loss

Gross Weight *

Enter Gross Weight

Standard Weight *

Enter Standard Weight

Hopper Dry *

Select Hopper Dry

MTC *

Select MTC

HRTC *

Select HRTC

If Yes Then Only Open Table
Below (Table Expandable s... i.e Z1
TO Z~ . Ask No. of
Zones for Each If Yes

MTC

HRTC

Z1

Z2

Expand Number of zones

| Material | 1 | 2 | 3 | 4 | 5 | 6 |
|--------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Grade | <div></div> | <div></div> | <div></div> | <div></div> | <div></div> | <div></div> |
| Mixing Ratio | <div></div> | <div></div> | <div></div> | <div></div> | <div></div> | <div></div> |

Temperature :

| | | | | | | |
|-------------------|--------|----|----|----|----|----|
| BARREL temp.°C | NOZZLE | Z1 | Z2 | Z3 | Z4 | Z5 |
| | | | | | | |

| | | | | | | |
|---------------|----------|-------|---|---|---|---|
| Mould Open | | Start | 2 | 3 | 4 | 5 |
| | Speed | | | | | |
| | Pressure | | | | | |
| | Position | | | | | |

| | | | | | | |
|--------------------------------|----------|-------|---|--------|--------|---------|
| Mould Close | | Start | 2 | 3 | Safety | Locking |
| | Speed | | | | | |
| | Pressure | | | | | |
| | Position | | | | | |
| Mould Protection Time(Sec.) | SET | | | Actual | | |

| | | | | | | |
|---------|----------|--------|-------------------------|----------|----------|---|
| Ejector | MODE | Repeat | rokes No. Of Strokes | | STAY FWD | |
| | FORWARD | 1 | 2 | RETRACT | 1 | 2 |
| | Speed | | | Speed | | |
| | Pressure | | | Pressure | | |
| | | | | | | |

| | | | | | | |
|--|----------|--|--|----------|--|--|
| | Position | | | Position | | |
|--|----------|--|--|----------|--|--|

| | | | | | | |
|--------------|---------------|----|-----|----------|----|-----|
| CORE PULL | Sequence | | | | | |
| | CORE 1 | IN | OUT | CORE 2 | IN | OUT |
| | Speed | | | Speed | | |
| | Pressure | | | Pressure | | |
| | Position/Time | | | Position | | |

| | | | | | | |
|-------------------|---------------|---|---|--------|---|---|
| INJECTION | Sequence | | | | | |
| | | 1 | 2 | 3 | 4 | 5 |
| | Speed | | | | | |
| | Pressure | | | | | |
| | Position/Time | | | | | |
| Injection Time | SET | | | Actual | | |

| | | | | | |
|---------|---------------|---|---|-------|--|
| HOLDING | | 1 | 2 | Total | |
| | Speed | | | | |
| | Pressure | | | | |
| | Position/Time | | | | |

| | | | | | | |
|--|-------|---|---|---|---|----------|
| | | 1 | 2 | 3 | 4 | SUCKBACK |
| | Speed | | | | | |

| | | | | | | |
|-----------|----------|----------------------|----------------------|----------------------|----------------------|----------------------|
| Refilling | Speed | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> |
| | Pressure | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> |
| | Position | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> |
| | | | Back Pressure | | ON/OFF | |

| Cooling Circuit | | No. Of Lines | |
|-----------------------|--------|----------------------------------|--|
| Cavity | IN/OUT | <input type="text" value="IN"/> | |
| | | <input type="text" value="OUT"/> | |
| Punch | IN/OUT | <input type="text" value="IN"/> | |
| | | <input type="text" value="OUT"/> | |
| Cooling Time(Sec.) | | <input type="text"/> | |
| Cycle Time(Sec.) | | <input type="text"/> | |
| Production Auto/Semi | | <input type="text"/> | |
| Average Production/Hr | | <input type="text"/> | |

| | |
|------------|----------------------|
| Checked by | <input type="text"/> |
|------------|----------------------|

Submit